

Work Order ID 81937

81937

Page 1

March-21-12 9:51:19 AM

Item ID: D4545-042

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Retainer, Inner, RH (Lower)

Stop *NS2*

Start Date: 21/03/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/12 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4545

B

100 Pick Kit

0.00

100

Packaging Memo

0.00

Packaging

110

0.00

110

Small Fab Memo

0.00

Small Fab

1- ASSEMBLE AND BEND TABS AS PER DWG

2- TRANSFER DRILL HOLES AS PER DWG.

3- DISASSEMBLE AND DEBURR

4- DIMPLE HOLES AS PER DWG

Handwritten signature and date 12/03/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81937

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Page 2

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Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Retainer, Inner, RH (Lower)

Start Date: 21/03/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	0.00							
Hand Finishing									
140	QC7-Inspect Chemical Conversion Coat	0.00							
140									
QC	Memo	0.00							
Quality Control									

2 12-03-22

2 BL 12-3-22

2 X 1 M / 12/03/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID 81937

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

March-21-12 9:51:19 AM

Item ID: D4545-042 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Retainer, Inner, RH (Lower)
 Start Date: 21/03/2012 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 04/04/2012 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 Memo START TIME: <u>10h35</u> OVEN TEMPERATURE: <u>320°F</u> FINISH TIME: <u>11h05</u>	0.00 0.00				2	0	(20)	12/03/23.
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				2	13	12323.	
170 *170* Small Fab Small Fab	INSTALL NUT PLATES AS PER DWG Memo	0.00 0.00						(2)	

PTO

W/O: 81937		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12-03-22	145 146	Install nut plates before paint Permanent Change	A	12-03-22	2	 G742	 12-03-22

Part No: D4545-042 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 81937

March-21-12 9:51:19 AM

81937

Page 4

Item ID: D4545-042

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Retainer, Inner, RH (Lower)

Start Date: 21/03/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Run Start ***NR1***

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop ***NR2***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

SB 12/03/23

190

Identify as per dwg & Stock Location: 442

0.00

190

Packaging

Memo

0.00

Packaging

6/3/23 54 120

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

MLJ 12/03/26

MF

12-03-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

March-21-12 9:51:23 AM

Page 1

1

Work Order ID: 81937

81937

Parent Item: D4545-042

D4545-042

Parent Item Name: Retainer, Inner, RH (Lower)

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.01.13 new issue DD verf:JLM
12.02.27 AS PER DWG REV.B DD VERF:EC

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4541-2		Manufactured	No			100	Each	0.0000	1	2			
D4541-2													
Bracket													
D4542-2		Manufactured	No			100	Each	0.0000	1	2			
D4542-2													
Retainer, Inner, RH													
MS20426AD3-4		Purchased	No			170	Each	3,914.000	38	76			
MS20426AD3-4													
RIVET													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST316		3914							
				104374		1006							
				110398		2908							
MS21059L3K		Purchased	No			170	Each	0.0000	18	36			
MS21059L3K													
Nutplate													
MS21061L3K		Purchased	No			170	Each	49.0000	1	2			
MS21061L3K													
NUT PLATE													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST303		49							
				120242		49							

B81261**

B81264**

**

**

**

**

M121114 (36x)**

S 12/03/22

S 12/03/22

S 12/03/23

76

S 12/03/23

S 12/03/23

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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ITEM	QTY -041	QTY -042	QTY -043	QTY -044	QTY -045	QTY -046	QTY -047	QTY -048	PART NUMBER	DESCRIPTION
	X								D4545-041	RETAINER, LH INNER (LOWER)
		X							D4545-042	RETAINER, RH INNER (LOWER)
			X						D4545-043	RETAINER, LH INNER (SIDE)
				X					D4545-044	RETAINER, RH INNER (SIDE)
					X				D4545-045	RETAINER, LH INNER (TOP CORNER)
						X			D4545-046	RETAINER, RH INNER (TOP CORNER)
							X		D4545-047	RETAINER, LH INNER (TOP)
								X	D4545-048	RETAINER, RH INNER (TOP)
1	1								D4541-1	BRACKET
2		1							D4541-2	BRACKET
3			1	1					D4541-3	BRACKET
4					1	1			D4541-5	BRACKET
5							1	1	D4541-7	BRACKET
6	1								D4542-1	RETAINER
7		1							D4542-2	RETAINER
8			1	1					D4542-3	RETAINER
9					1	1			D4542-5	RETAINER
10							1	1	D4542-7	RETAINER
11	40	38	28	28	12	12	16	16	MS20426AD3-4	RIVET
12	19	18	14	14	6	6	8	8	MS21059L3K	NUTPLATE
13	1	1							MS21061L3K	NUTPLATE

~~81937~~ M.C.J
81937 12/03/21

RELEASED
2012-02-16

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIOR TO ASSEMBLY, POWDER COAT D4541-X & D4542-X WITH BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: -041/-042 = 0.38 lbs, -043/-044 = 0.27 lbs,
-045/-046 = 0.11 lbs, -047/-048 = 0.15 lbs
- 8) BEND INDIVIDUAL TABS ON D4541-X BRACKETS TO CORRESPONDING "A#" (A1, A2, ETC.,) VALUE

B	ADD FINISH (ZN A8-1)	CP	12.02.01
A	NEW ISSUE	CP	12.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.02.01		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4545	REV. B SHEET 1 OF 9
TITLE RETAINER, INNER	SCALE NTS
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W/O:		WORK ORDER CHANGES					
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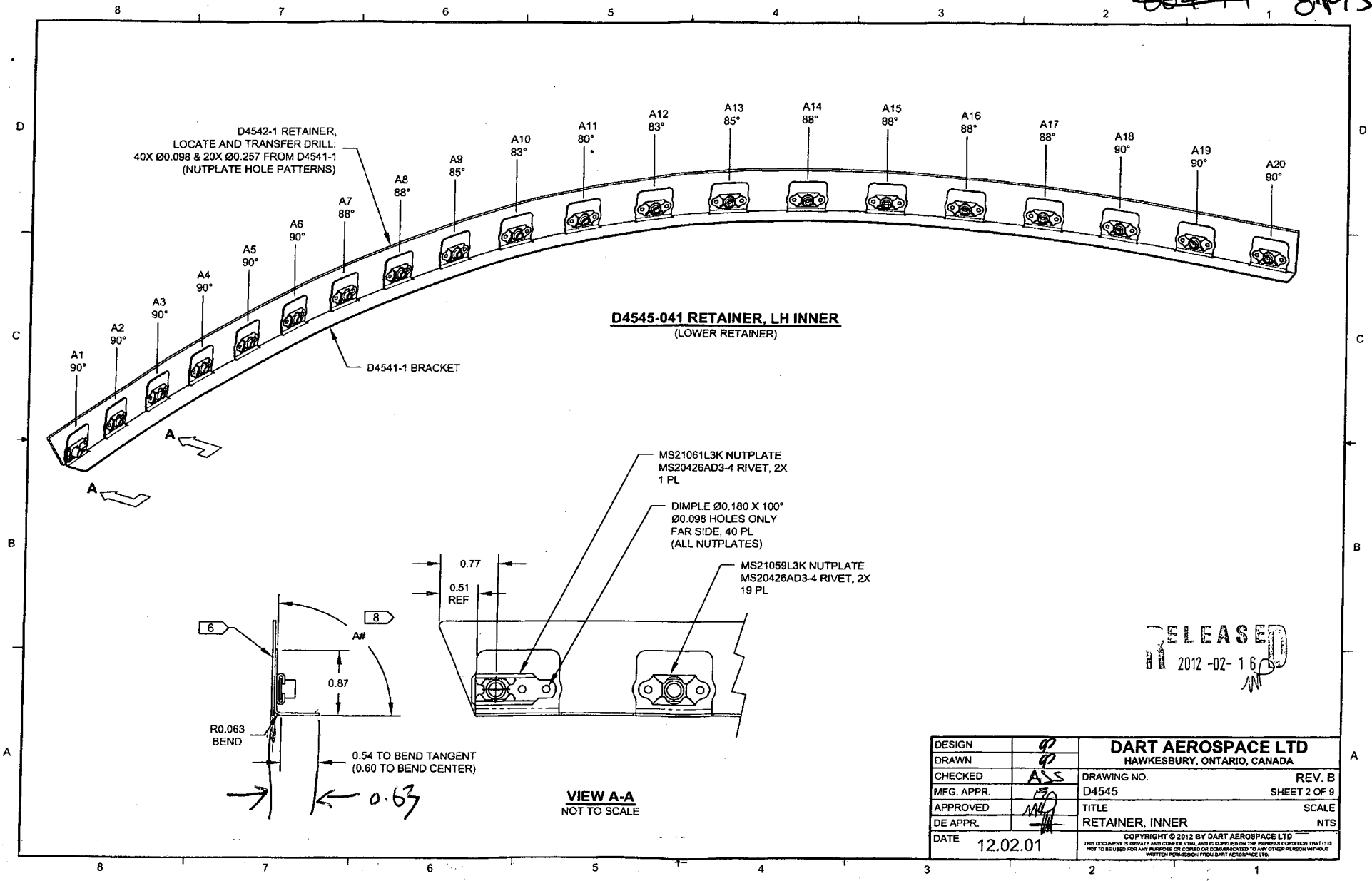
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

~~8017A~~ 81937



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2012-02-16

DESIGN	92	DART AEROSPACE LTD	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. B
MFG. APPR.		D4545	SHEET 2 OF 9
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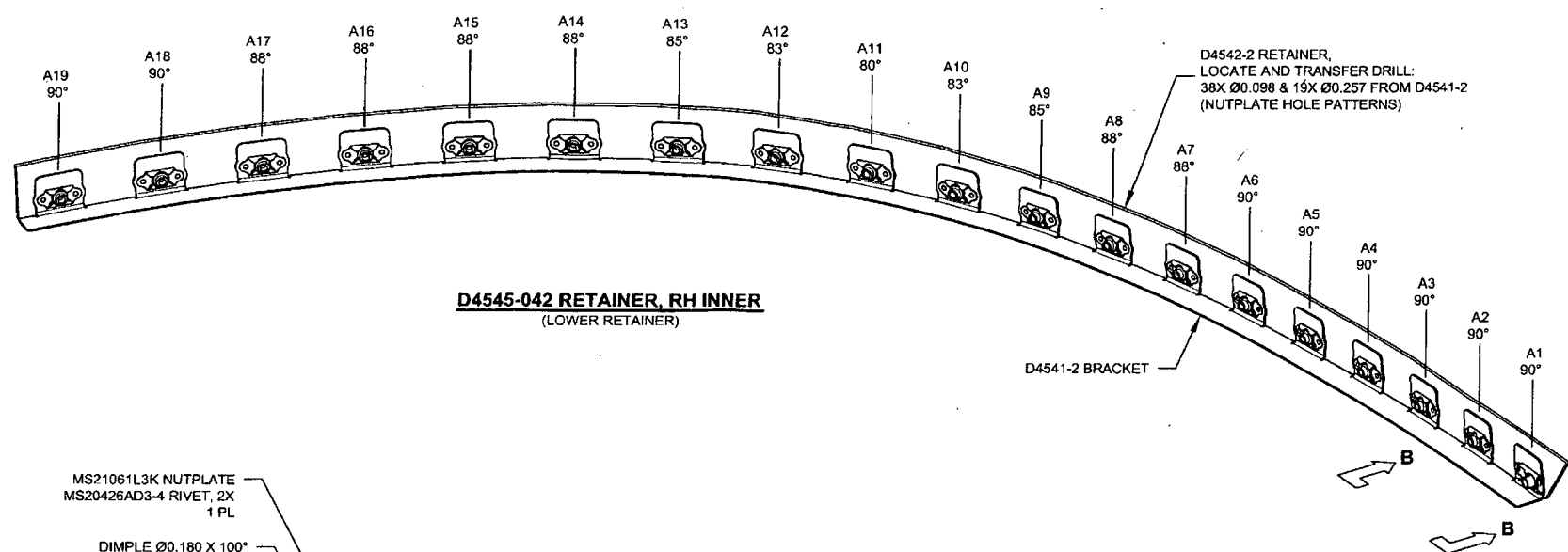
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

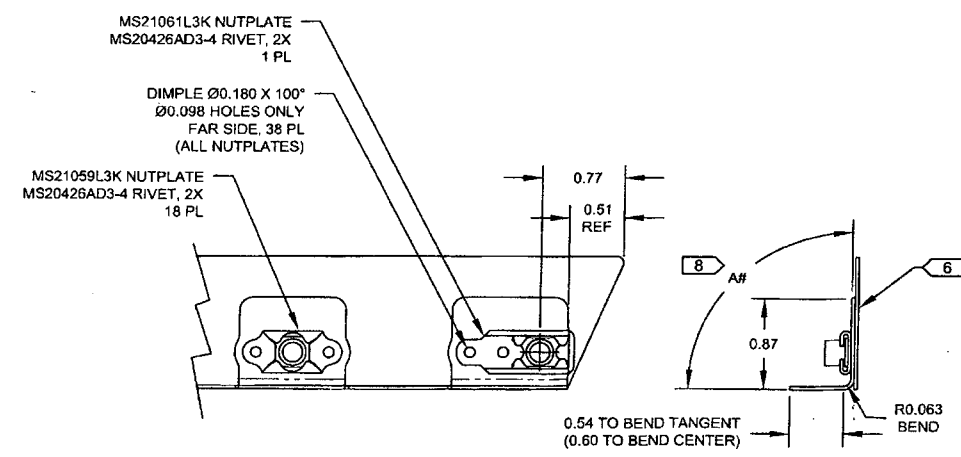
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

~~80977~~ 81937



D4545-042 RETAINER, RH INNER
(LOWER RETAINER)



VIEW B-B
NOT TO SCALE

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2012-02-16

DESIGN	90	DART AEROSPACE LTD	
DRAWN	90	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. B
MFG. APPR.	30	D4545	SHEET 3 OF 9
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81937

D4542-3 RETAINER,
LOCATE AND TRANSFER DRILL:
28X Ø0.098 & 14X Ø0.257 FROM D4541-3

D4545-043 RETAINER, LH INNER
(SIDE RETAINER)

D4541-3 BRACKET

MS21059L3K NUTPLATE
MS20426AD3-4 RIVET, 2X
14 PL

DIMPLE Ø0.180 X 100°
Ø0.098 HOLES ONLY
FAR SIDE, 28 PL

VIEW C-C
NOT TO SCALE

0.54 TO BEND TANGENT
(0.60 TO BEND CENTER)

R0.063
BEND

DESIGN	90	DART AEROSPACE LTD	
DRAWN	90	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. B
MFG. APPR.	50	D4545	SHEET 4 OF 9
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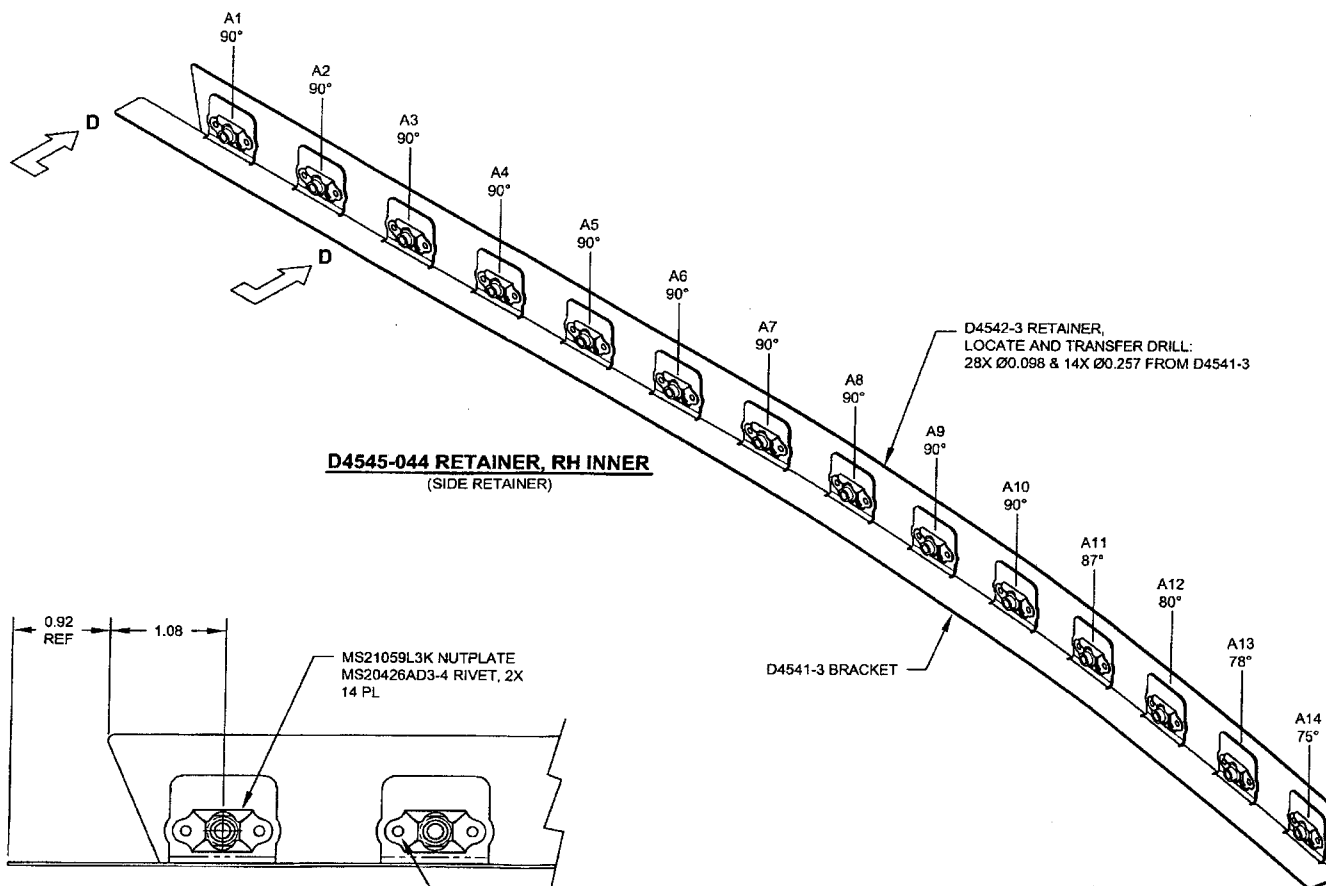
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

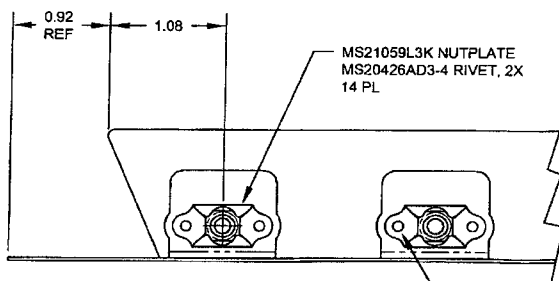
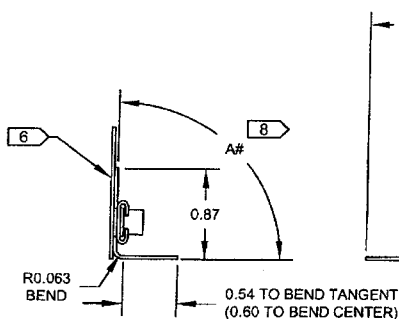
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D4545-044 RETAINER, RH INNER
(SIDE RETAINER)



VIEW D-D
NOT TO SCALE

DIMPLE Ø0.180 X 100°
Ø0.098 HOLES ONLY
FAR SIDE, 28 PL

RELEASED
2012-02-16

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4545	SHEET 5 OF 9
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Dart Aerospace Ltd

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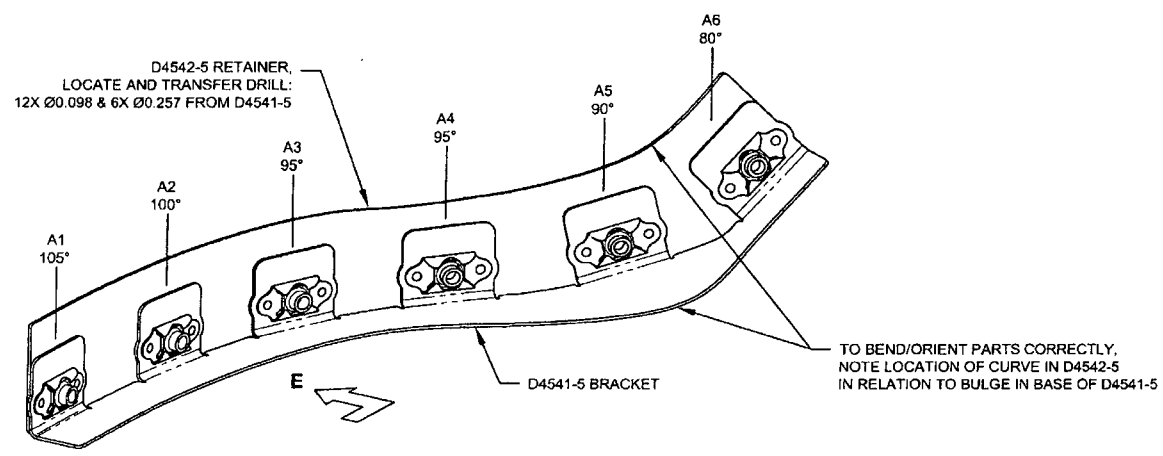
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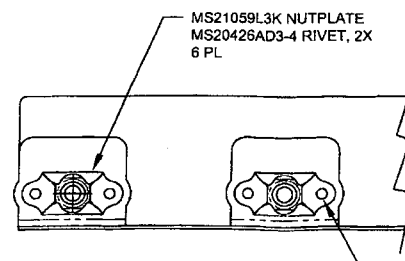
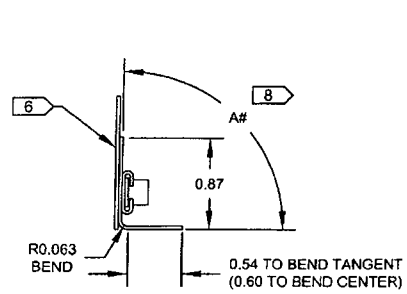
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D4545-045 RETAINER, LH INNER
(TOP CORNER RETAINER)



VIEW E-E
NOT TO SCALE

RELEASED
2012-02-16

DESIGN	90	DART AEROSPACE LTD	
DRAWN	90	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. B
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Dart Aerospace Ltd

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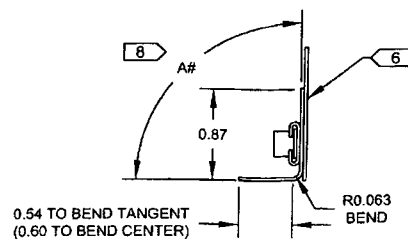
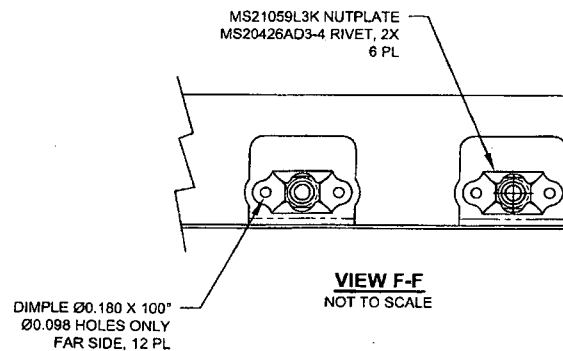
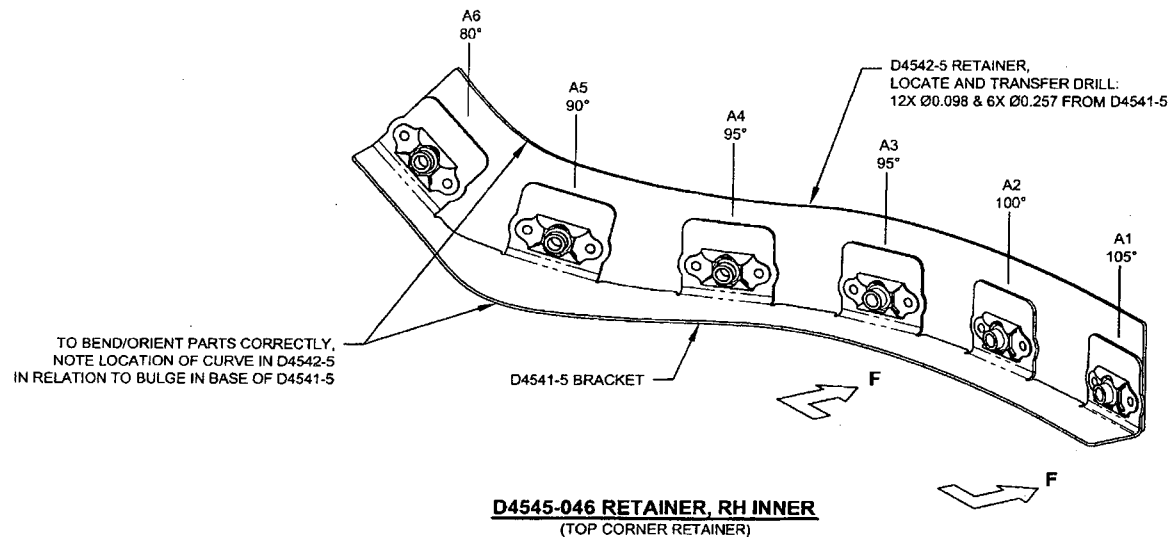
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RELEASED
2012-02-16
JMO

DESIGN	qp	DART AEROSPACE LTD	
DRAWN	qp	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. B
MFG. APPR.		D4545	SHEET 7 OF 9
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

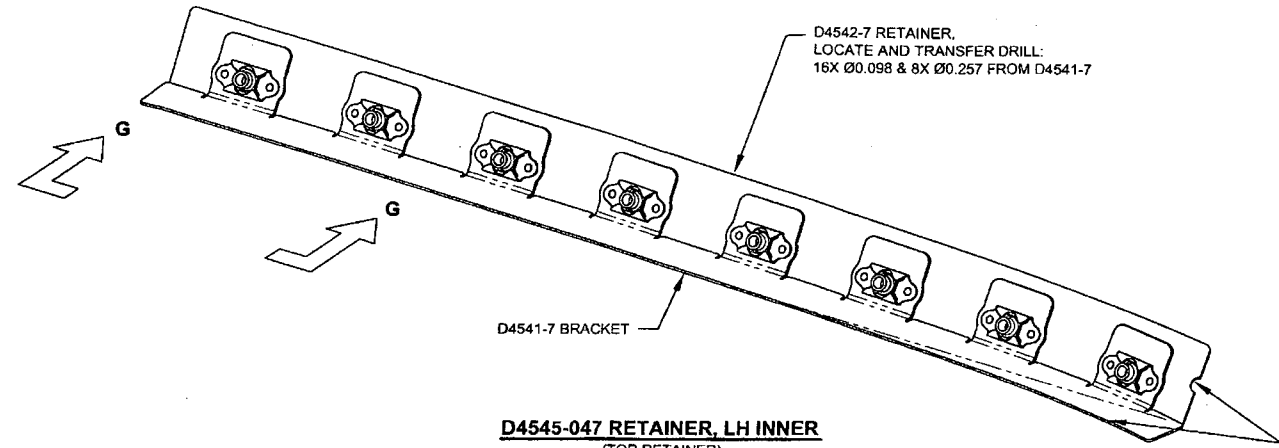
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

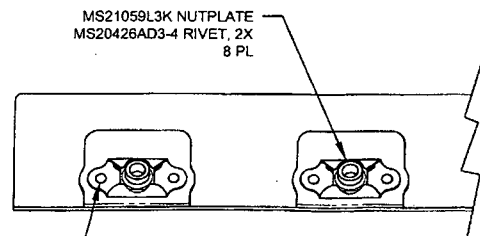
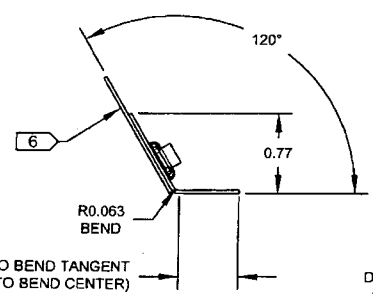
81937

~~80437~~



D4545-047 RETAINER, LH INNER
(TOP RETAINER)

TO BEND/ORIENT PARTS CORRECTLY,
NOTE LOCATION OF TOOLING MARK IN D4542-7
IN RELATION TO CURVE IN BASE OF D4541-7



DIMPLE Ø0.180 X 100°
Ø0.098 HOLES ONLY
FAR SIDE, 16 PL

VIEW G-G
NOT TO SCALE

RELEASE
2012-02-16

DESIGN	90	DART AEROSPACE LTD	
DRAWN	90	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ALS	DRAWING NO.	REV. B
MFG. APPR.	13	D4545	SHEET 8 OF 9
APPROVED	13	TITLE	SCALE
DE APPR.	13	RETAINER, INNER	NTS
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W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

81937

~~81937~~

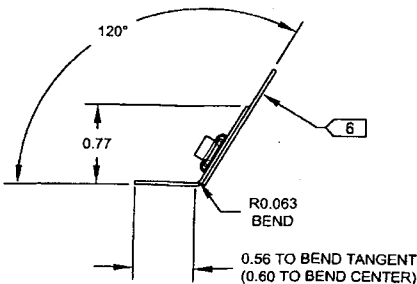
D4542-7 RETAINER,
LOCATE AND TRANSFER DRILL:
16X Ø0.098 & 8X Ø0.257 FROM D4541-7

D4541-7 BRACKET

D4545-048 RETAINER, RH INNER
(TOP RETAINER)

TO BEND/ORIENT PARTS CORRECTLY,
NOTE LOCATION OF TOOLING MARK IN D4542-7
IN RELATION TO CURVE IN BASE OF D4541-7

MS21059L3K NUTPLATE
MS20426AD3-4 RIVET, 2X
8 PL



DIMPLE Ø0.180 X 100°
Ø0.098 HOLES ONLY
FAR SIDE, 16 PL

VIEW H-H
NOT TO SCALE

RELEASE
2012-02-16

DESIGN	90	DART AEROSPACE LTD	
DRAWN	90	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. B
MFG. APPR.	ED	D4545	SHEET 9 OF 9
APPROVED		TITLE	SCALE
DE APPR.		RETAINER, INNER	NTS
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NOTE: Date & initial all entries